



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173484



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Crosstubes-2		PMP
100	Mori Seiki	1 pcs		3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs		3/15/18	0.00	0.00	QC1	QC2	PMP
120	Mori Seiki	1 pcs		3/15/18	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs		3/15/18	0.00	0.00	QC1	QC2	PMP
140	QC	1 pcs		3/15/18	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs		3/15/18	0.00	0.25	Crosstubes-2		SA 18-04-19
150	HandFXtube	1 pcs		3/16/18	0.00	0.25	Crosstubes-3		SA 18-04-19
160	QC	1 pcs		3/16/18	0.00	0.00	QC7-1		SA 18-04-19
170	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-1		SA 18-04-19
180	QC21-SA	1 Ea		3/16/18	0.00	0.00	QC21		SA 18-04-19

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

8123 969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:42 AM Dart.Gagnon.Michelle



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Container No: S050473



Part: D212-664-201TRN

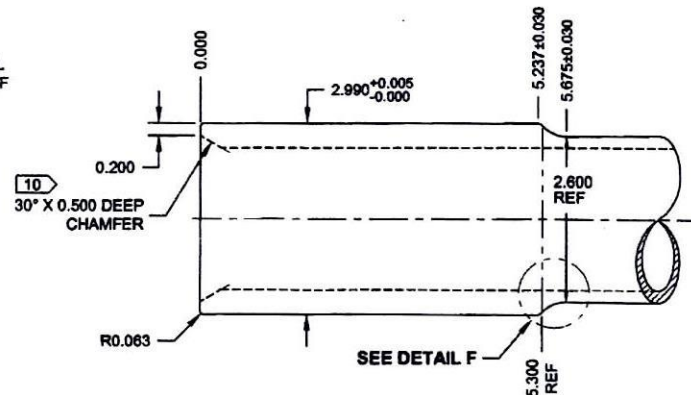
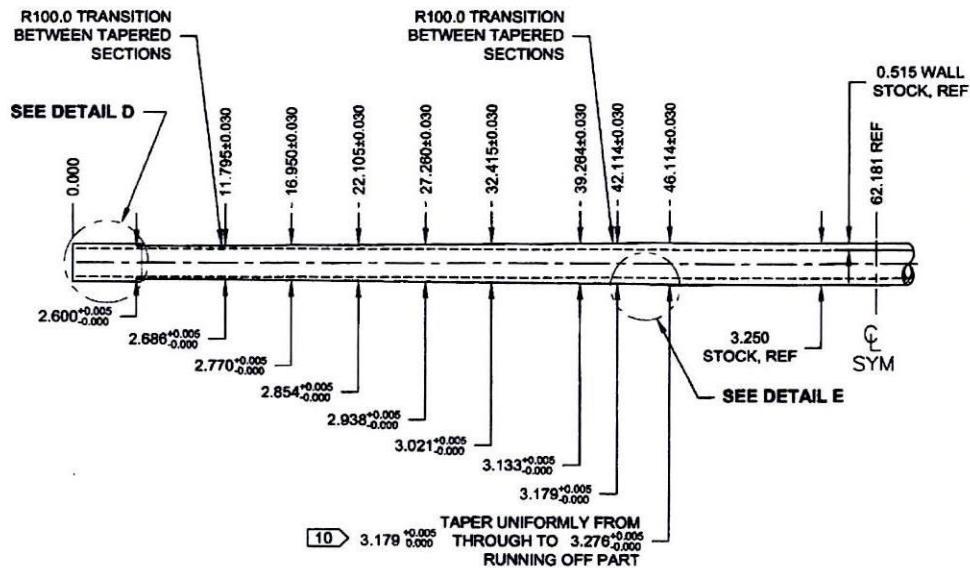
Job No: 173484

Serial No/Batch: S050473

Revision:

Inspector:

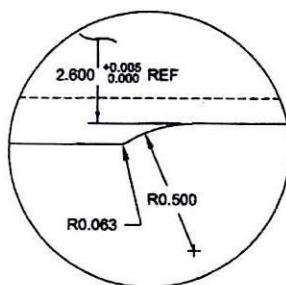
Date: 03/12/18



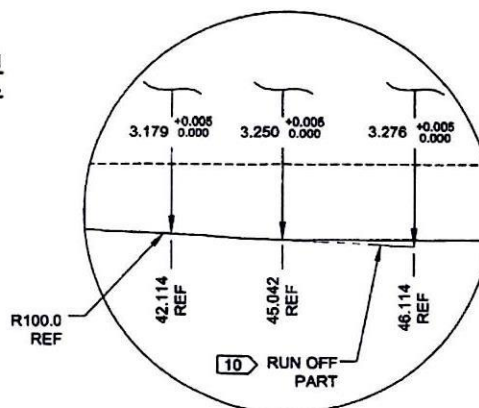
DETAIL D:
CROSSTUBE CUFF
SCALE 5X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173484
MAR 02 2018

RELEASED
2014-05-26



DETAIL F:
CUFF TRANSITION
SCALE 10X



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

DESIGN	<i>g</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>g</i>			
CHECKED	<i>g</i>		DRAWING NO.	REV. E
MFG. APPR.	<i>g</i>		D212-664-241	SHEET 5 OF 5
APPROVED	<i>g</i>		TITLE	SCALE
DE APPR.	<i>g</i>		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

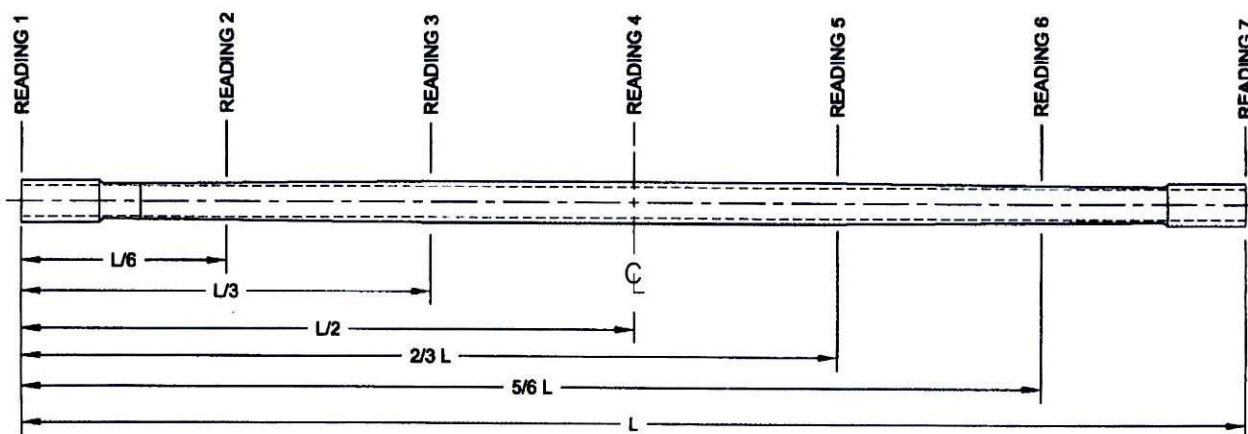
DART AEROSPACE LTD		Work Order:	173484
Description: Crosstube Assembly (205/212 High Aft)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	✓		VERN OF	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.993	✓		VERN OF	
	5.237	+/-0.030	5.234	✓		"	
	2.600	+0.005/-0.000	2.605	✓		RLM 2" 3" 04	
	2.686	+0.005/-0.000	2.691	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.943	✓		"	
	3.021	+0.005/-0.000	3.024	✓		RLM 3" 4" 05	
	3.133	+0.005/-0.000	3.136	✓		"	
	3.179	+0.005/-0.000	3.182	✓		"	
	.500	±.01	.500	✓		RG	
	.063	±.01	.063	✓		RG	
SIDE B	0.200	+/-0.010	.200	✓		VERN OF	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.993	✓		VERN OF	
	5.237	+/-0.030	5.241	✓		"	
	2.600	+0.005/-0.000	2.605	✓		RLM 2" 3" 04	
	2.686	+0.005/-0.000	2.691	✓		"	
	2.770	+0.005/-0.000	2.775	✓		"	
	2.854	+0.005/-0.000	2.859	✓		"	
	2.938	+0.005/-0.000	2.943	✓		"	
	3.021	+0.005/-0.000	3.026	✓		RLM 3" 4" 05	
	3.133	+0.005/-0.000	3.137	✓		"	
	3.179	+0.005/-0.000	3.183	✓		"	
	124.362	+/-0.020	124.360	✓		+APE	
	.500	±.01	.500	✓		RG	
	.063	±.01	.063	✓		RG	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	388	407	424	404	.036	0.062"
READING 2 L = 20.73	308	335	347	329	.039	
READING 3 L = 41.45	482	500	506	490	.024	
READING 4 L = 62.18	525	533	535	528	.010	
READING 5 L = 82.91	495	502	500	485	.017	
READING 6 L = 103.64	318	334	341	324	.023	
READING 7 L = 124.36	402	404	410	411	-.008	

Calibration Result

Actual Block Thickness: 382 500

Sitiescan 250 Measured Thickness: 382 502

Measured by: PMP	Audited by:	Preliminary Approval:
Date: 2018-03-12	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	